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D3914-041
Job Sheet 203188



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	12/12/19		0.00	10.00	Large Fab - 1		MAL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	12/12/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
120	QC 5	1	12/12/19		0.00	0.00	QC 5 - 12		DAS 43 9-89
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



Container No: S240387



Part: D3914-041

Job No: 203188

Serial No/Batch: S240387

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/16/19

Plex 11/11/19 3:22 PM Dart.lajeunesse.marie

						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
						Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
130	Powdercoat - 4 Black Sand - B4B	1	12/12/19	0.00	0.40	Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
						QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
135	QC 3	1	12/12/19	0.00	0.00	QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
140	Handfinish - 3-1- WingWalk- B4B	1	12/12/19	0.00	0.80	QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150	QC 3	1	12/12/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	

BE 19-12-20

MR 19-12-20

MR 19-12-20

BE 19-12-20

DAS
15
9-89

DAS
59
9-89

						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						Packaging 3 - 1 - B4B	Jul 19 - 12-20
						Packaging 3 - 2 - B4B	
160 Packaging 3-1 - Stock - B4B	1 pcs	12/12/19	0.00	0.00		Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
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						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	

					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	1 pcs	12/12/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	DEC 20 2019

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M139015 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214321
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5237045
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5236908
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5221460
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5225334
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	5229696
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5229416
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5232735

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	67	0
	D3914-1	2	6	0
	D3914-7	2	6	0
	D4016-3	3	356	0
	D4018-5	9	53	0
	D4020-5	1	11	0
	D4021-3	1	33	0
	D4035-043	2	0	0

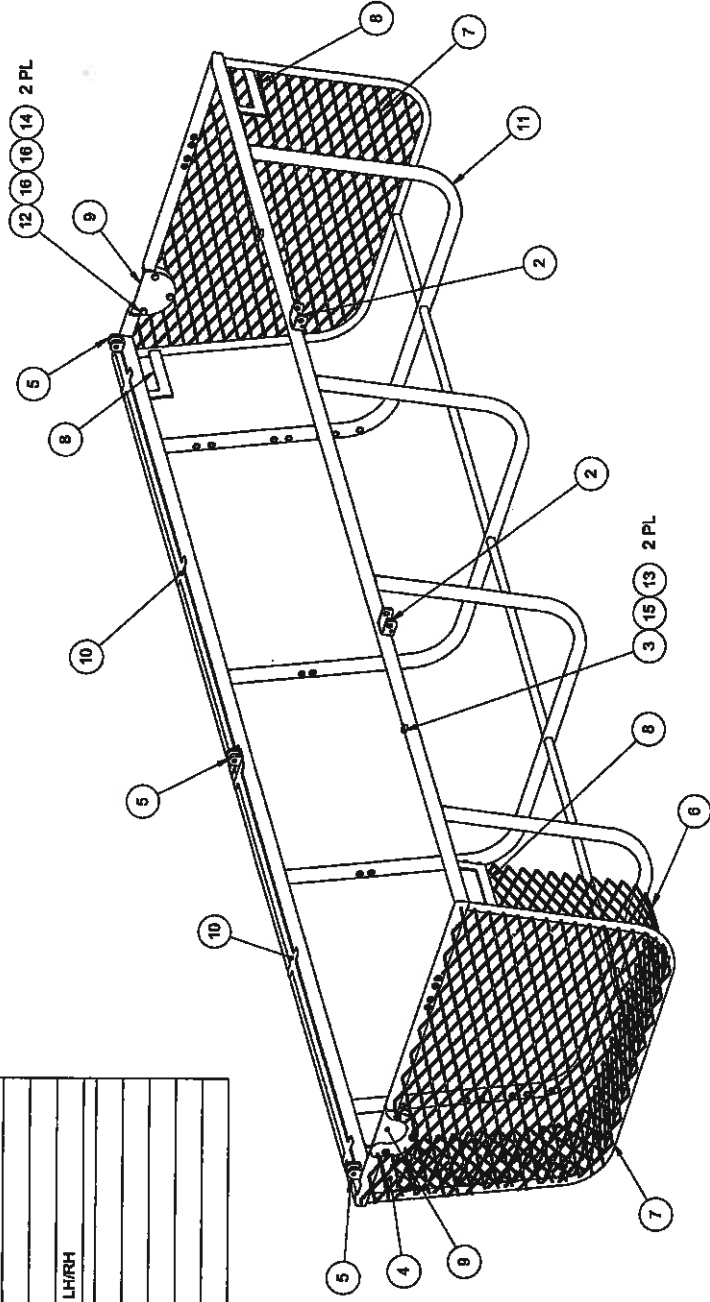
Part Specifications

Specifications could not be found.

013401

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation				Disposition					
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D5068-041	LONG BASKET BASE ASSY LHRH
2	2	D2581	MOUNTING BRACKET
3	2	D2831	BUMPER
4	1	D3813-15	WIDE HANDLE PLATE
5	3	D4018-1	HINGE HALF, BASE
6	1	D4020-1	MESH BASKET LONG, BASE
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	1	D5068-101	TUBULAR ASSEMBLY, LHRH
12	6	AN3-10A	BOLT
13	2	MS20800AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1148DN832J	WASHER
16	12	NAS1148F0332P	WASHER



NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: SCRIBE DART P/N AND FIN USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
7) WEIGHT: 50.42 lbs APPROX
8) INSTALL AFTER FINISH
9) MASK PRIOR TO POWDER COAT
10) WELD PER DART QSI 004

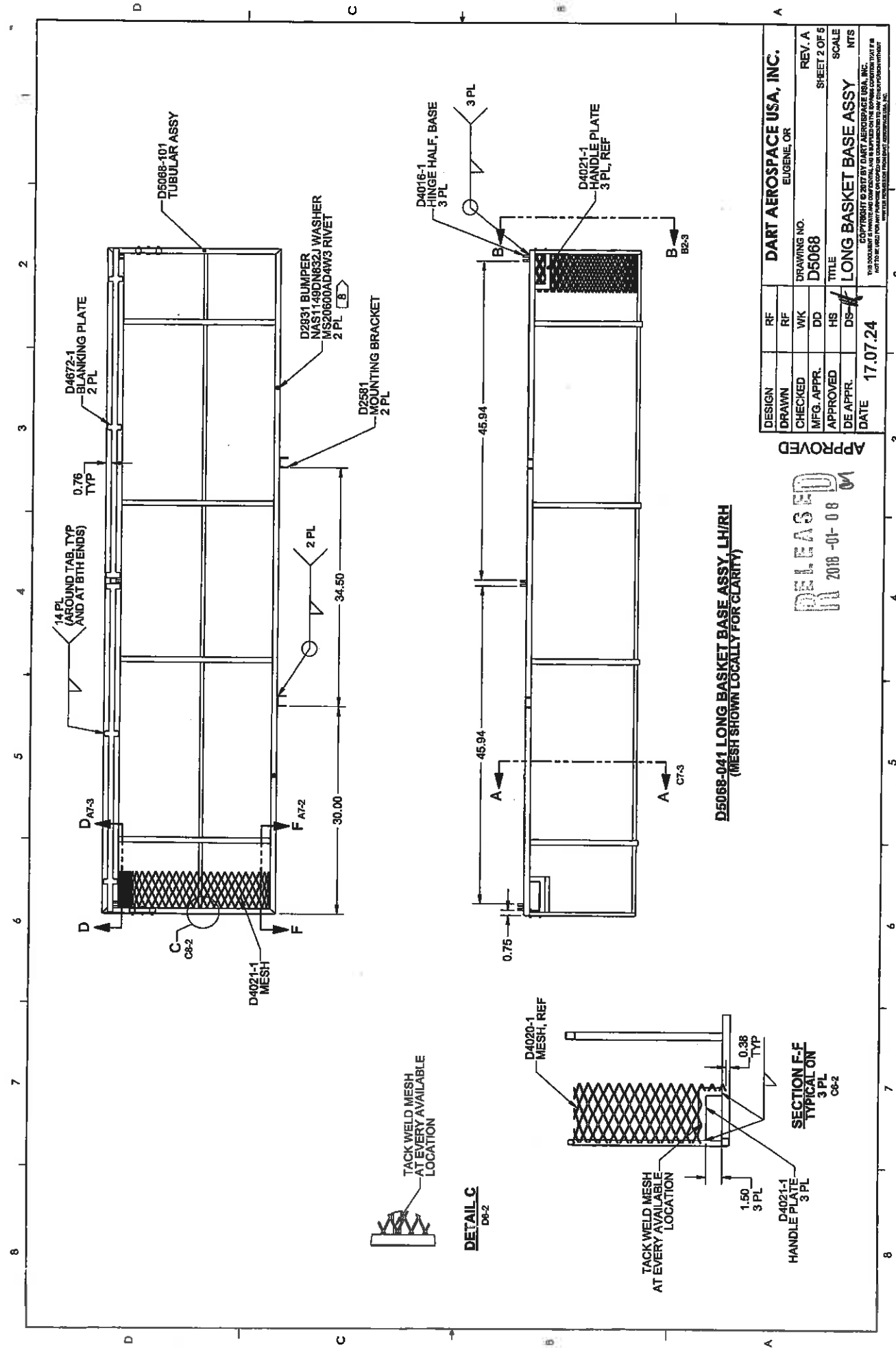
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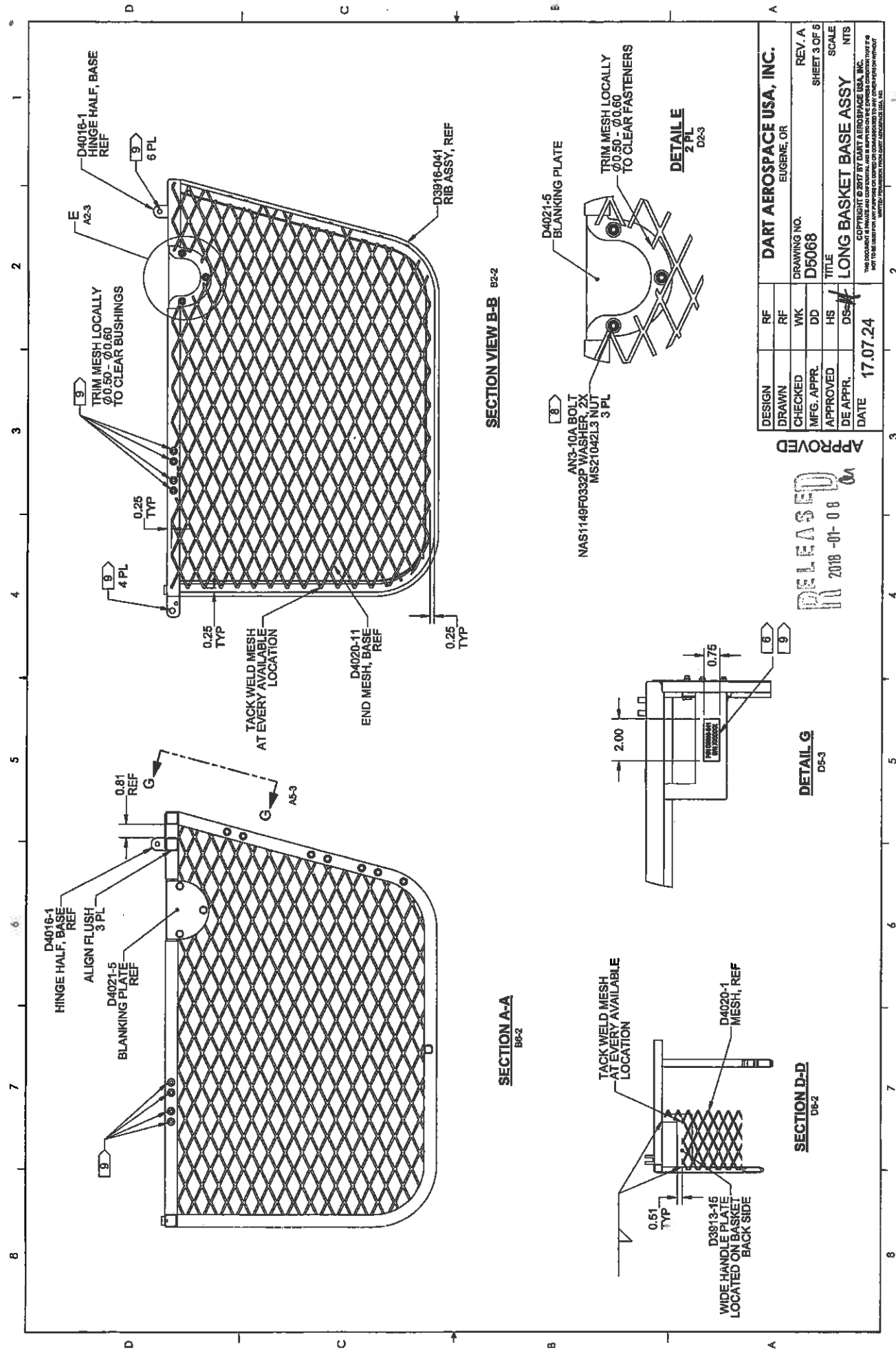
RELEASED
2018-01-08
EWR-773

APPROVED

REV.	NEW ISSUE	DESCRIPTION	RF	BY	DATE
A					17.07.24
DESIGN	RF	DESCRIPTION	RF	BY	DATE
DRAWN	RF				
CHECKED	WK	DART AEROSPACE USA, INC.			
MFG. APPR.	DD	DRAWING NO. D5068			
APPROVED	HS	TITLE			
DE APPR.	DS	LONG BASKET BASE ASSY			
DATE	17.07.24	SCALE			
		NTS			

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2018-01-08 RELEASED

